

Work Order ID 58646

Wednesday, May 12, 2010 1:55:39 PM



Page 1

Item ID: D3686-041

Accept



Setup Start



Revision ID:

Stop



Item Name: MONOPOD ASSEMBLY

Start Date: 5/13/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: mfDate: 10-5-12 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3686

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

SB 10/06/22

(4)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

2-Assemble D3693-1 & D3691-1 & D3693-3 & D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3686

SB 10/06/22

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/06/23



130

Identify as per dwg & Stock Location: 1390

0.00



Packaging

Memo

0.00

Packaging

C 10/06/23 (Y)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24

C 10/06/24

Dart Aerospace Ltd

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Picklist Print

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Work Order ID: 58646

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Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Date: 5/13/2010

Required Date: 5/21/2010

Start Qty: 4.00

Required Qty: 4.00

D3688-7 Manufactured No 110 Each 12.0000 1



STUD

Location	Loc Qty	Loc Code
ST081	12	
44686	1	
46055	3	
46699	1	
50931	7	

3 18/06/22

D3689-1 Manufactured No 110 Each 16.0000 1



SLEEVE

Location	Loc Qty	Loc Code
ST082	16	
55638	11	
56335	5	

4 18/06/22

D3691-1 Manufactured No 110 Each 1.0000 1



STUD

Location	Loc Qty	Loc Code
ST082	1	
54859	1	

4 18/06/22

D3692-1 Manufactured No 110 Each 521.0000 4



SPACER

Location	Loc Qty	Loc Code
ST082	521	
50736	113	
51467	408	

46 18/06/22

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IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Start Qty: 4.00

Required Qty: 4.00

D3692-3 Manufactured No 110 Each 61.0000 4



SPACER

Location Loc Qty Loc Code

ST082 61
44690 61

D3693-1 Manufactured No 110 Each 63.0000 1



Rod End Bearing

Location Loc Qty Loc Code

ST082 63
50734 63

D3693-3 Manufactured No 110 Each 10.0000 1



Rod End Bearing

Location Loc Qty Loc Code

ST082 10
50723 10

AN3C10A Purchased No 110 Each 54.0000 2



Bolt

Location Loc Qty Loc Code

ST351 54
105940 34
112489 20

64 SB 10/06/22 (4)

4 SB 10/06/22 (4)

4 SB 10/06/22 (4)

8 SB 10/06/22 (4)

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Shop Packet Print

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Start Date: 5/13/2010

Required Date: 5/21/2010

Start Qty: 4.00

Required Qty: 4.00

AN3C12A

Purchased

No

110

Each

104.0000

2



Bolts

Location

Loc Qty

Loc Code

ST351

104

112314

104

MS21043-3

Purchased

No

110

Each

3,635.000

4



Nut

Location

Loc Qty

Loc Code

FG

80

103691

80

ST301

3555

112314

3555

NAS509L12C

Purchased

No

110

Each

74.0000

1



Nuts

Location

Loc Qty

Loc Code

ST280

74

112314

64

112828

10

NAS509-12C

Purchased

No

110

Each

69.0000

1



Nuts

Location

Loc Qty

Loc Code

ST280

69

112453

69

8 10/06/22 (4)

16 10/06/22 (4)

4 10/06/22 (4)

4 10/06/22 (4)

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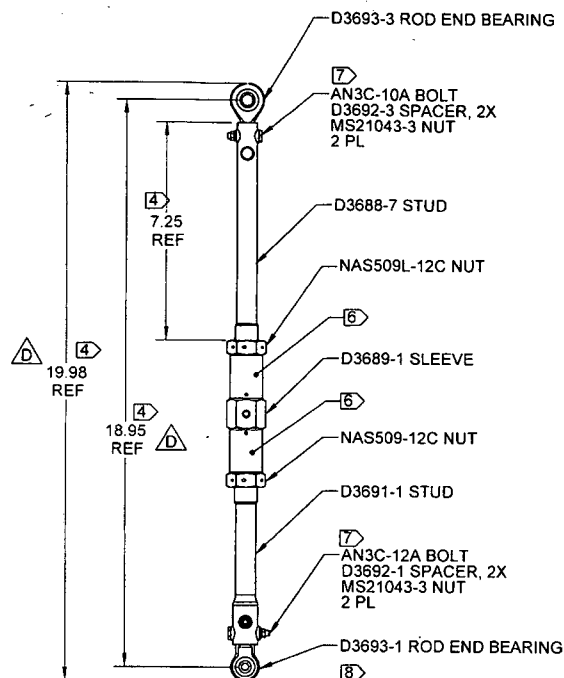
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONOPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONOPOD ASSEMBLY

RELEASED
2010-03-15
JW

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

D	19.98 WAS 20.10 (ZN C6-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	RF	D3686	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MONOPOD ASSEMBLY	NTS
DATE	10.03.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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